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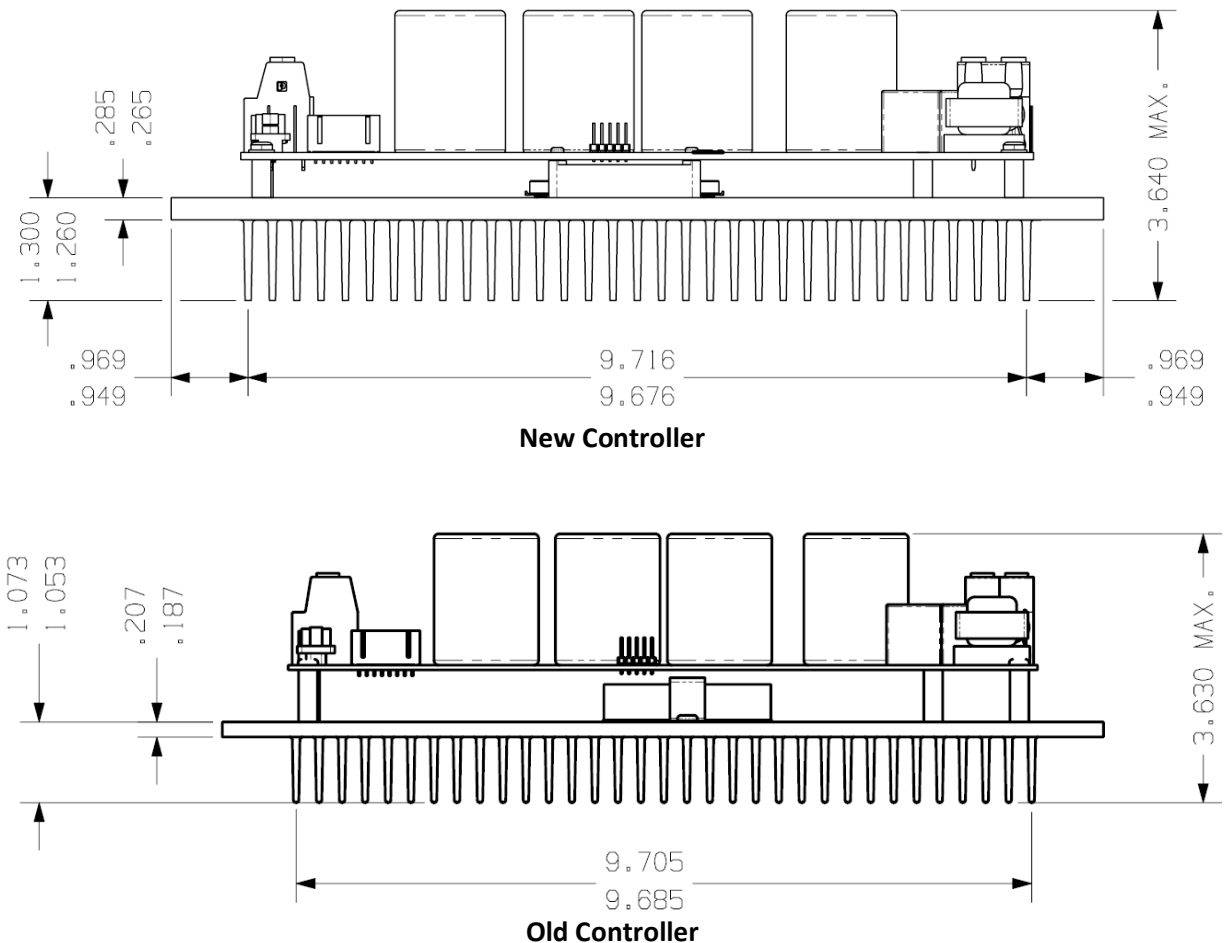
From: North American Applications Engineering Team
To: Tecumseh/Masterflux Authorized Wholesalers and OEMs
Date: March 18, 2020
Subject: **Product Update: 025F0XXX-XX Controller Change**

PRODUCT BULLETIN

Description of Changes

Tecumseh Products Company would like to inform our valued customers of a change to our 80-300V SIERRA controllers. We have made a change to the controller module. We have also made changes to the heatsink geometry to accommodate this change. Due to the module and heatsink changes, the modified controllers will receive new part numbers. These changes will not affect controller software or functionality. The information below will detail these changes, the affected controller part numbers, and the new controller part numbers.

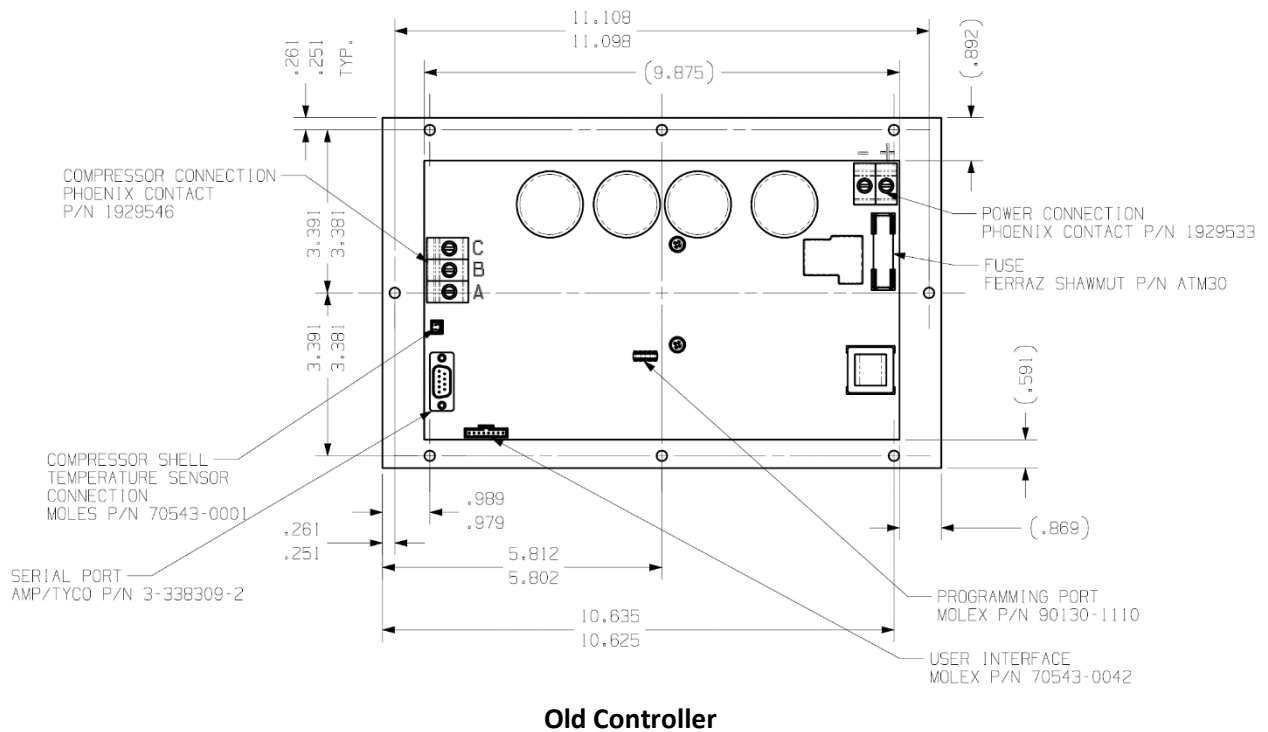
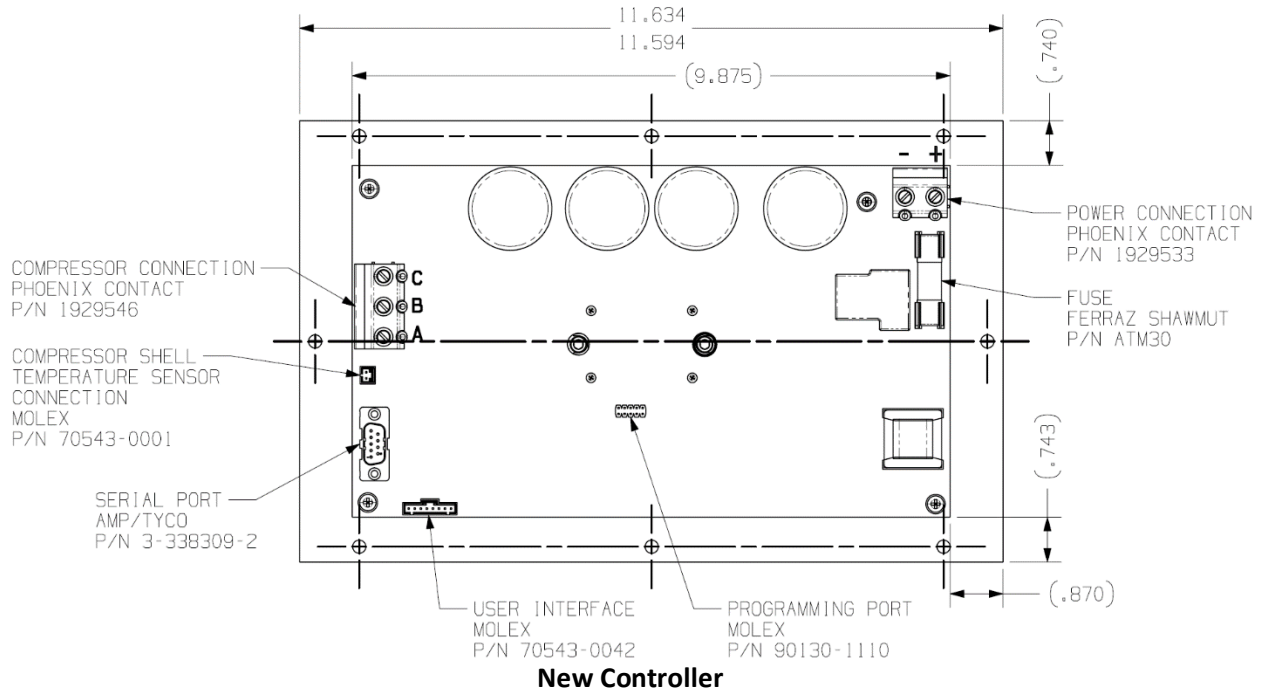
Figure 1: Front View Comparison





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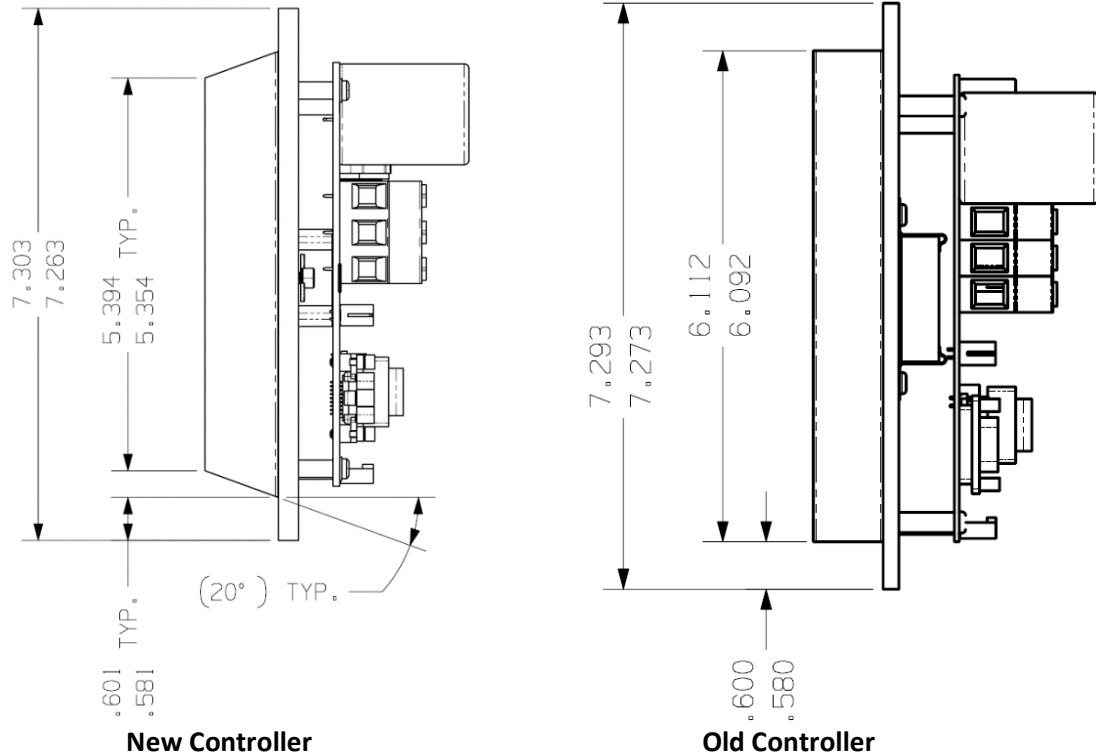
Figure 2: Top View Comparison





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Figure 3: Side View Comparison



Production Timing

Below is a comprehensive list of the affected part numbers and their replacement part numbers. The current part numbers will be phased out and discontinued as soon as possible.

Old Part Number	Description	New Part Number
025F0093-03	Assy, Controller, 300VDC, ALPINE	025F0402
025F0140-01	Assy, Controller, 120VDC, SIERRA	025F0395
025F0140-02	Assy, Controller, 220VDC, SIERRA	025F0397
025F0140-03	Assy, Controller, 300VDC, SIERRA	025F0398
025F0140-04	Assy, Controller, 80VDC, SIERRA	025F0391
025F0140-05	Assy, Controller, 100VDC, SIERRA	025F0393
025F0140-06	Assy, Controller, 200VDC, SIERRA	025F0396
025F0140-07	Assy, Controller, 110VDC, SIERRA	025F0394
025F0140-09	Assy, Controller, 90 VDC, SIERRA	025F0392
025F0188-03	Assy, Controller, 300VDC, SIERRA, Dual	025F0401
025F0188-04	Assy, Controller, 80VDC, SIERRA, Dual	025F0400



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Questions

Should you have additional questions that have not been addressed, please do not hesitate to contact your local Tecumseh Sales Representative or Technical Service Team (800.211.3427). For more information on our Masterflux compressor series, please visit our website masterflux.com